

SHIP ABOVE TO OFFSHORE DO NOT ASSEMBLE

Work Order ID 112711

Wednesday, February 05, 2014 2:58:35 PM

112711

Page 1

Item ID: D3391-025

Accept

N900040100

Set

Imp Sta

NS1

Revision ID:

Item Name: Aft Tube Assembly

Stop

NS2

Start Date: 2/5/2014 **Start Qty:** 1.00

*1 *

Cust Item ID:

Required Date: 2/14/2014 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals: **Process Plan:**

Date: 14-02-6

Tooling:

Date:

Ru

Start

NB1

NB2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								
100		0.00							
100	MORI SEIKI CNC LATHE LARGE								
Mori Seiki									
Mori Seiki CNC Lathe Large									
	Memo	0.00							
	Turn as per Folio FA599		Rev: A	& Dwg D3391 Rev: A					
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC									
Quality Control									
	Memo	0.00							
112	QC5- Inspect part completeness to step on W/O	0.00							
112									
QC									
Quality Control									
	Memo	0.00	DAS	27	8.89				
			14/2/24						

Work Order ID 112711

Wednesday, February 05, 2014 2:58:35 PM

112711

Page 2

Item ID: D3391-025

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Tube Assembly

Start Date: 2/5/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/14/2014 Req'd Qty: 1.00

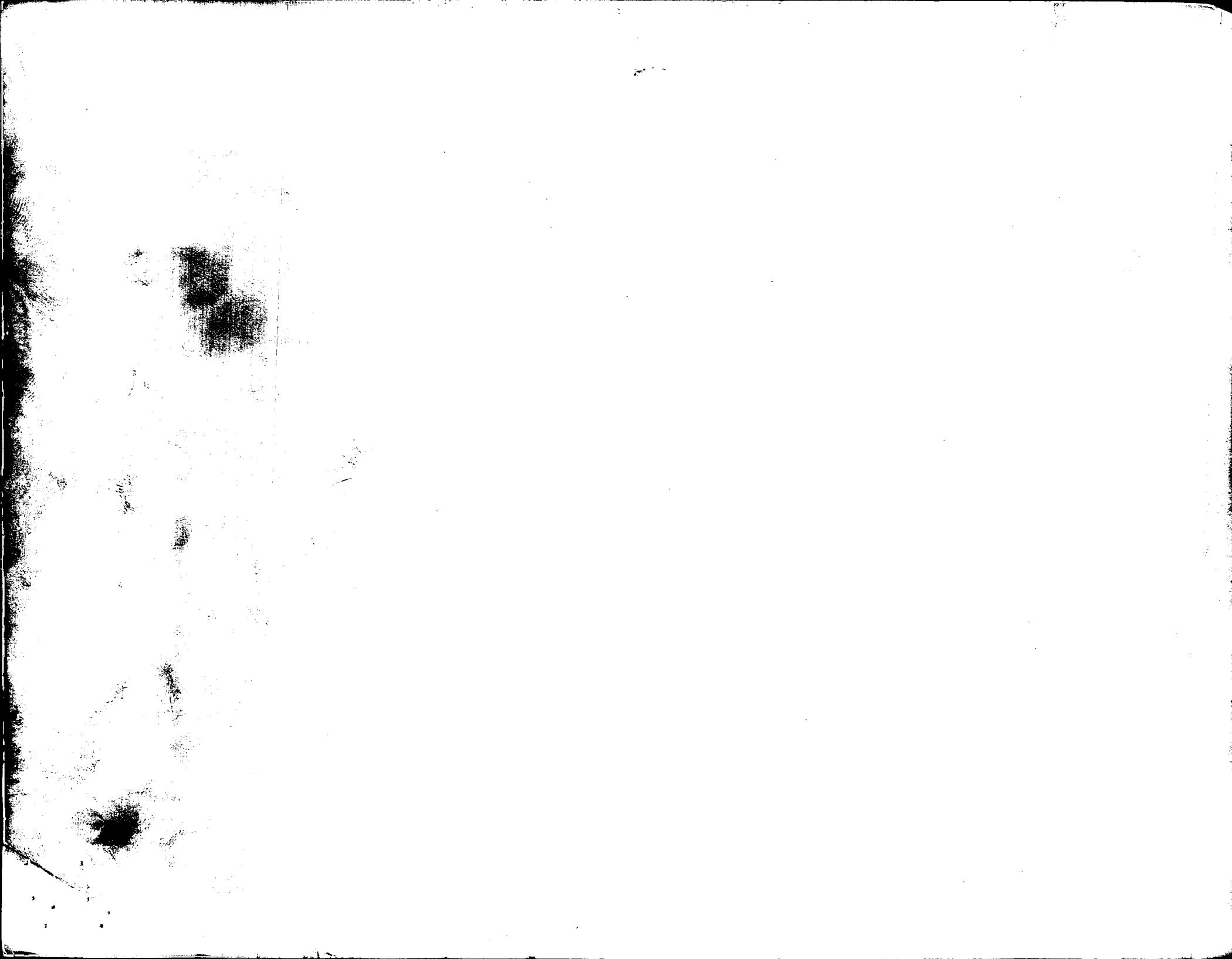
1

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
						Stop	*NR2*
	QC:	Date:	SPC (Y/N):	Date:			

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* HAAS 1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Machine as per Folio FA 599 Rev: <u>44</u> & Dwg D3391 Rev: <u>I</u> 2-Deburr	0.00 0.00	<i>anl</i>	<i>14/03/16</i>		<u>1</u>	<u>0</u>		
130 *130* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	<i>anl</i>	<i>14/03/16</i>		<u>1</u>	<u>0</u>		
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo ***INSPECT INSIDE BORE***	0.00 0.00	<i>B.a</i>	<i>14/03/19</i>		<u>1</u>	<u>0</u>		DAS 08 9-89



Work Order ID 112711

Wednesday, February 05, 2014 2:58:35 PM

112711

Page 3

Item ID: D3391-025

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Tube Assembly

Start Date: 2/5/2014 Start Qty: 1.00 *1*

Required Date: 2/14/2014 Req'd Qty: 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____

Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID
150
150

Operation
Description
Skidtubes

Set Up/
Run Hours
0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

DC 14/03/19

Skidtubes

Skidtubes

Memo
1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

160

160

GNC Bend

GNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

DC 14/03/25

170

170

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Memo
Form as per Dwg D3391 Using Bend Prog 3391025

H 4.26

DAS
03
9.89

14-3-25

10-10

Work Order ID 112711

Wednesday, February 05, 2014 2:58:35 PM

112711

Page 4

Item ID: D3391-025

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft Tube Assembly

Start Date: 2/5/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/14/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center ID
180***180***

Skidtubes

Skidtubes

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217
Wearplate Jig.

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.297" and c'bore as per dwg D3391

6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391.

7-Deburr

8- Scribe batch # on fwd end

DCV4/03/28

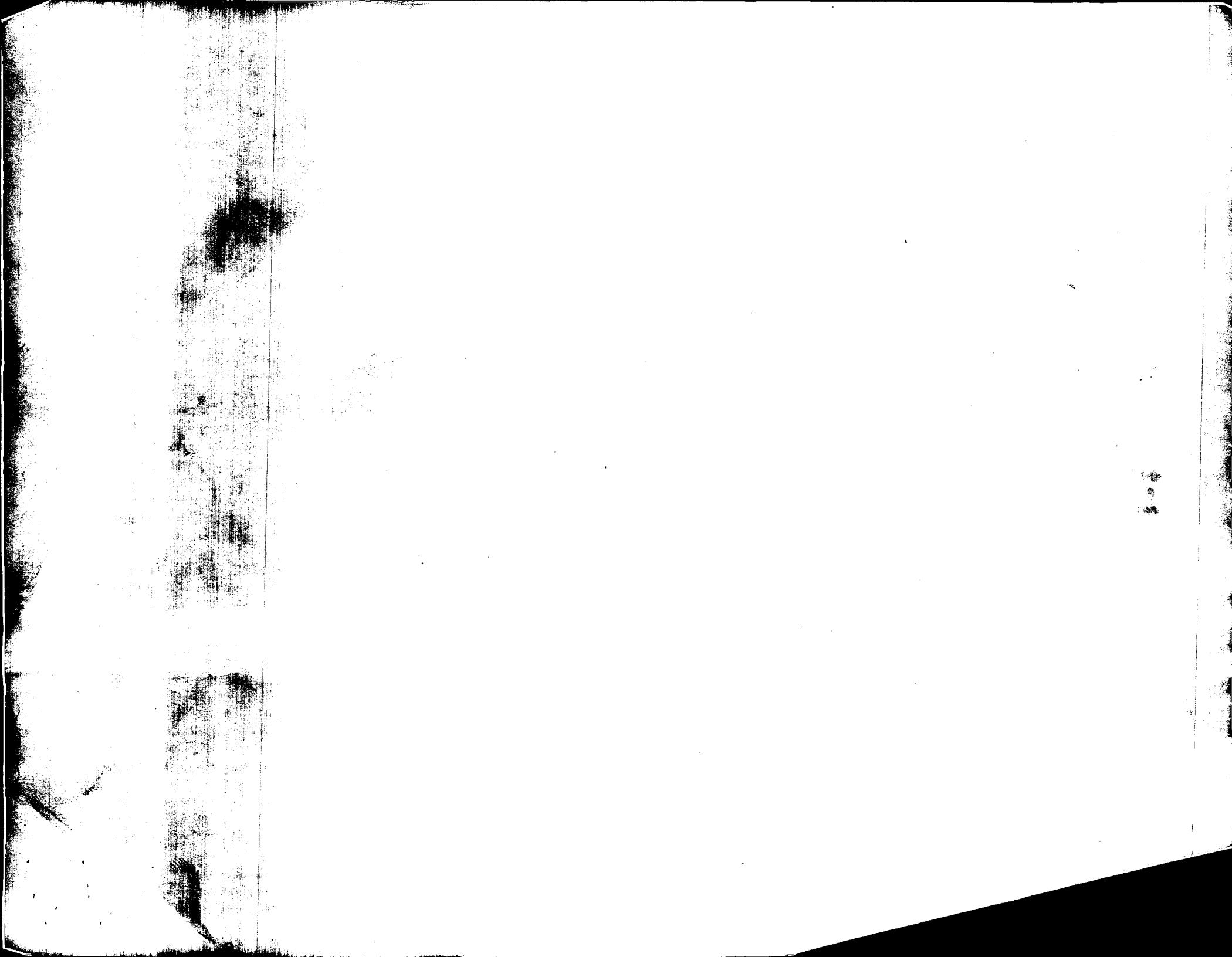
Work Order ID 112711

Wednesday, February 05, 2014 2:58:35 PM

112711

Item ID:	D3391-025	Accept	*N900040100*	Setup	Start	*NS*	
Revision ID:				Stop		*NS2*	
Item Name:	Aft Tube Assembly						
Start Date:	2/5/2014	Start Qty:	1.00	*1*	Cust Item ID:		
Required Date:	2/14/2014	Req'd Qty:	1.00	*1*	Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *1Q0* QC	QC5- Inspect part completeness to step on W/O Quality Control	0.00						① 14-03-31	
200 *2Q0* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00						14-3-31	JCC/ADG
210 *210* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00						1 8 2014/03/31	



Work Order ID 112711

Wednesday, February 05, 2014 2:58:35 PM

112711

Page 6

Item ID: D3391-025

Accept

Revision ID:

Item Name: Aft Tube Assembly

Start Date: 2/5/2014 Start Qty: 1.00

1

Required Date: 2/14/2014 Req'd Qty: 1.00

1***N900040100***

Setup Start

NS1

Stop

NS2

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center ID
220***220***

Skidtubes

Skidtubes

Operation
DescriptionSet Up/
Run Hours
0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Skidtubes

Memo

0.00

1- Instal spacers as per dwg D3391
A/R Magnabond 6398 Batch: 127227
exp. date: 14/05/05
cure time 12hrs as per QSI0015

2- Grind crossbolts flush

3- Back drill using #9 drill

4- Touchup Magnabond

5- Deburr

> - DC 14/04/01

> - DC 14/04/01

230

QC5- Inspect part completeness to step on W/O

0.00

230

QC

Quality Control

Memo

0.00

① 11.04.02

DAS

9

9-89

Work Order ID 112711

Wednesday, February 05, 2014 2:58:35 PM

112711

Page 7

Item ID: D3391-025

Accept

Revision ID:

Item Name: Aft Tube Assembly

Start Date: 2/5/2014 Start Qty: 1.00

1

Required Date: 2/14/2014 Req'd Qty: 1.00

1***N900040100***

Setup

Start ***NS1***

Stop

NS2

Cust Item ID:

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
235 *235* HandFinish	Pressure Wash per QSI005 4.3	0.00				1		761442	
Hand Finishing	Memo AND REALODINE AS PER PAR09-043	0.00							
240 *240* Powdercoat	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				1	Φ 44-9.		DAS 34 9-89
Powder Coating	Memo START TIME: 145 OVEN TEMPERATURE: 820° FINISH TIME: 215	0.00							
250 *250* QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00							

Work Order ID 112711

Wednesday, February 05, 2014 2:58:36 PM

112711

Page 8

Item ID: D3391-025

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Aft Tube Assembly

Stop

NS2

Start Date: 2/5/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/14/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center ID
260***260***
HandFinish

Hand Finishing

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

HandFinishing

0.00

Memo

1-Install inserts as per Dwg D3391
2-Install Aft Cap as per Dwg D3391
A/R Sikaflex-241/-291 11128569
Sikaflex expiry date: 11/10Sik
Mullis

✓3- INSTALL WEARPLATES AS PER DWG

270

270
QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

280

280
Packaging

Packaging

Identify as per dwg & Stock Location: W1D

0.00

PACKAGING

Memo

0.00

OFFSHORE

1x / All 4/04/14
S 14-04-23

Work Order ID 112711

Wednesday, February 05, 2014 2:58:36 PM

112711

Page 9

Item ID: D3391-025

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft Tube Assembly

Stop

NS2Start Date: 2/5/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/14/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____ Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center ID
290Operation
Description
QC21- Final Inspection - Work Order ReleaseSet Up/
Run Hours
0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp***290***

QC

Quality Control

Memo

0.00

*R 14-11-23**R 14-11-23*

DQA:

Date:

QA Closed:

Date:

WORK ORDER NON-CONFORMANCE / UPDATEWork Order update only

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function		<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence					
						<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge					
						<input checked="" type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input checked="" type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock/Pulled <input type="checkbox"/> Other					

14-C-200-A-5

AGK

16 SEPTEMBER 1968

26-10

160000Z

Picklist Print

Wednesday, February 05, 2014 2:58:40 PM

Page 1

Work Order ID: 112711

112711

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 2/5/2014

Required Date: 2/14/2014

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev B	06-02-07	ECN773 dwg rev. D	EC
IPP Rev:C	06-03-28	Update Manuf. Instructions	JLM
IPP rev D	07.03.20	revF dwg	EC
IPP rev E	07.11.07	rev G dwg ecn 1053p	EC verified by: DD
IPP Rev:F	07-11-13	ECN 1056	DD verified by: EC
IPP Rev:G	08-09-10	revH as per dwg	DD verified by:EC IPP Rev:H
11.11.14 AS PER REV.I DD verified by:JLM			

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4095-047		Manufactured	No			260	Each	18.0000	1	1	**		

D4095-047

Wearpad Assembly

Location	Loc Qty	Loc Code
FP001	18	B108289
102241	2	
108289	16	

D4095-049

D4095-049

Wearpad Assembly

Location	Loc Qty	Loc Code
FP001	12	
109670	12	
FP002	1	
102216	1	

D6014-090

D6014-090

ALUMINUM EXTRUSION

Location	Loc Qty	Loc Code
LG003	77	
79742	17	
(86063)	60	

mm.L 14/02/18

Picklist Print

Wednesday, February 05, 2014 2:58:40 PM

Page 2

Work Order ID: 112711

112711
D3391-025

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 2/5/2014

Required Date: 2/14/2014

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No 230 Each

351.0000

4

4

**

DC 17 / 03 / 31

D3670-4-200

Bushing

Location	Loc Qty	Loc Code
FG	10	
87709	10	
LG001	341	
103880	60	
109108	242	
96240	39	

D2646

Manufactured No 270 Each

23.0000

1

1

**

DC 17 / 03 / 31

D2646

Aft Cap

Location	Loc Qty	Loc Code
FG	4	13113830
85848	2	X1
90495	2	
FP001	19	
103306	18	
107857	1	

D3672-1

Manufactured No 270 Each

850.0000

2

2

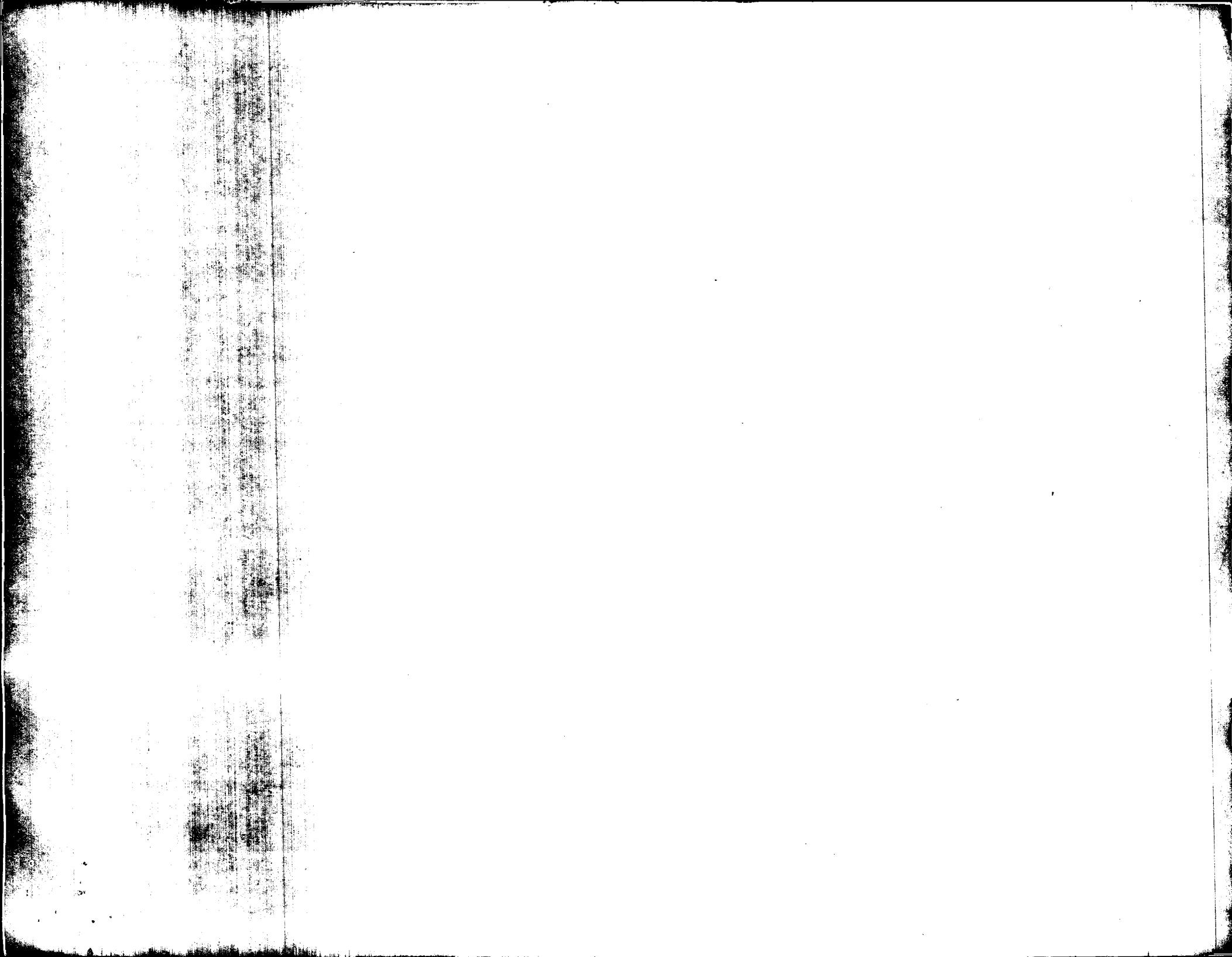
**

DC 17 / 03 / 31

D3672-1

Phenolic Washer

Location	Loc Qty	Loc Code
FG	10	
85222	10	
ST060	840	
103845	100	
93886	522	
99099	218	X2



Picklist Print

Wednesday, February 05, 2014 2:58:40 PM

Page 3

Work Order ID: 112711

112711
D3391-025

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 2/5/2014

Required Date: 2/14/2014

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130 AELS4-1032-130 Purchased No 260 Each

57.0000 14 14

**

AI S4-1032-130

Rivnut

ALS4-1032-225 AELS8-1032-225 Purchased No 270 Each

101.0000 8 8

**

AI S4-1032-225

Rivnut

Location

st510
M126109

Loc Qty

57
57

Loc Code

M1128649

X14

Location

FG
M127028
ST280
M127028
st555
M127092

Loc Qty

30
30
10
10
61
61

Loc Code

X9
6

AN3C4A

Purchased

No

270

Each

2,616.000

6

**

AN3C4A

Bolt

Location

FG
122814
ST513
125388
M127410
M127832

Loc Qty

20
20
2596
1835
261
500

Loc Code

M1128739
X6

Picklist Print

Wednesday, February 05, 2014 2:58:40 PM

Page 4

Work Order ID: 112711

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

112711
D3391-025

AN3C5A

Purchased No

270 Each

1,881.000 4 4

**

AN3C5A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FG	5	
122800	5	
ST350	1876	
M128057	1876	

NAS1149C0332R

Purchased No

270 Each

9,652.000 10 10

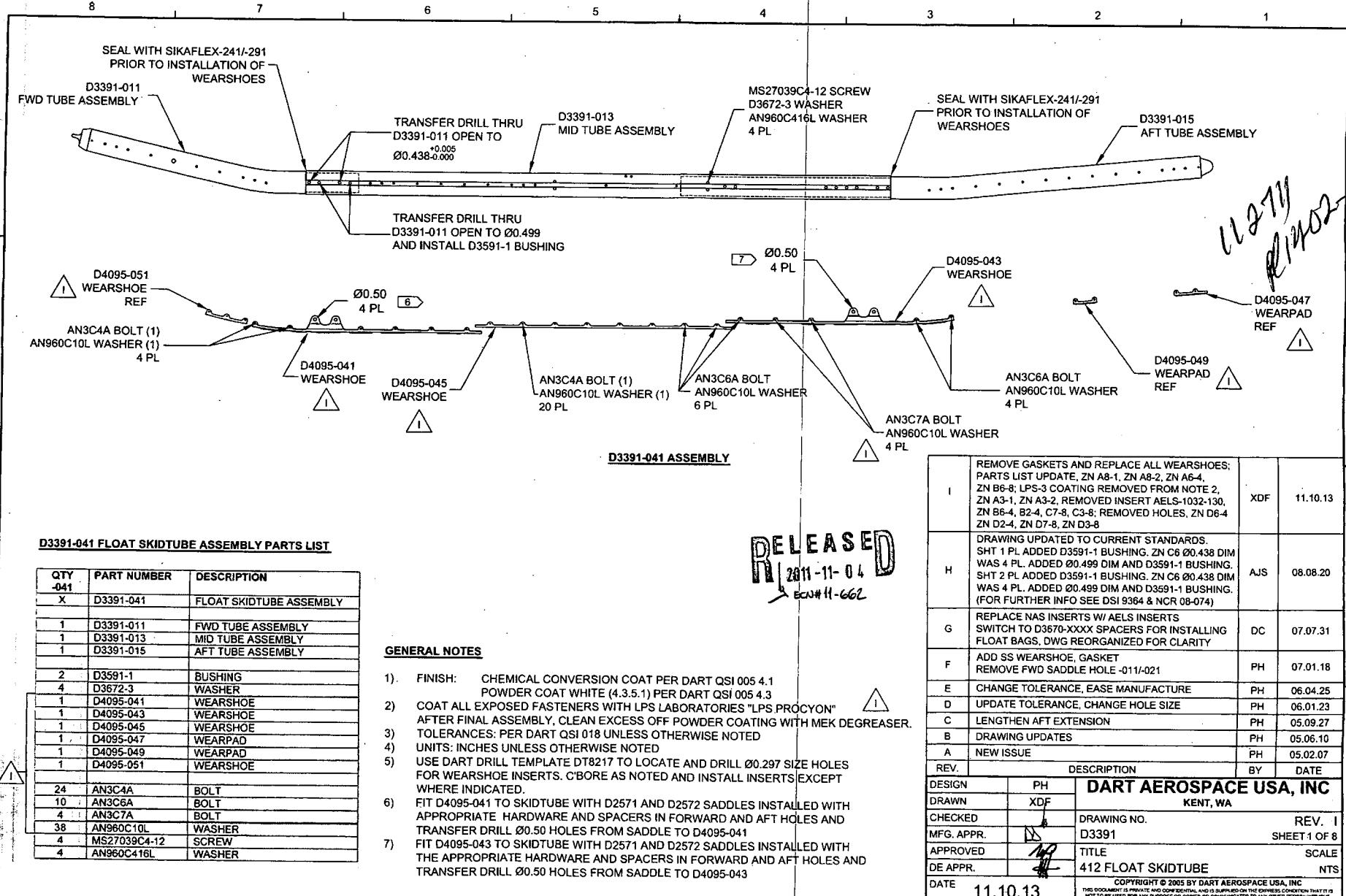
**

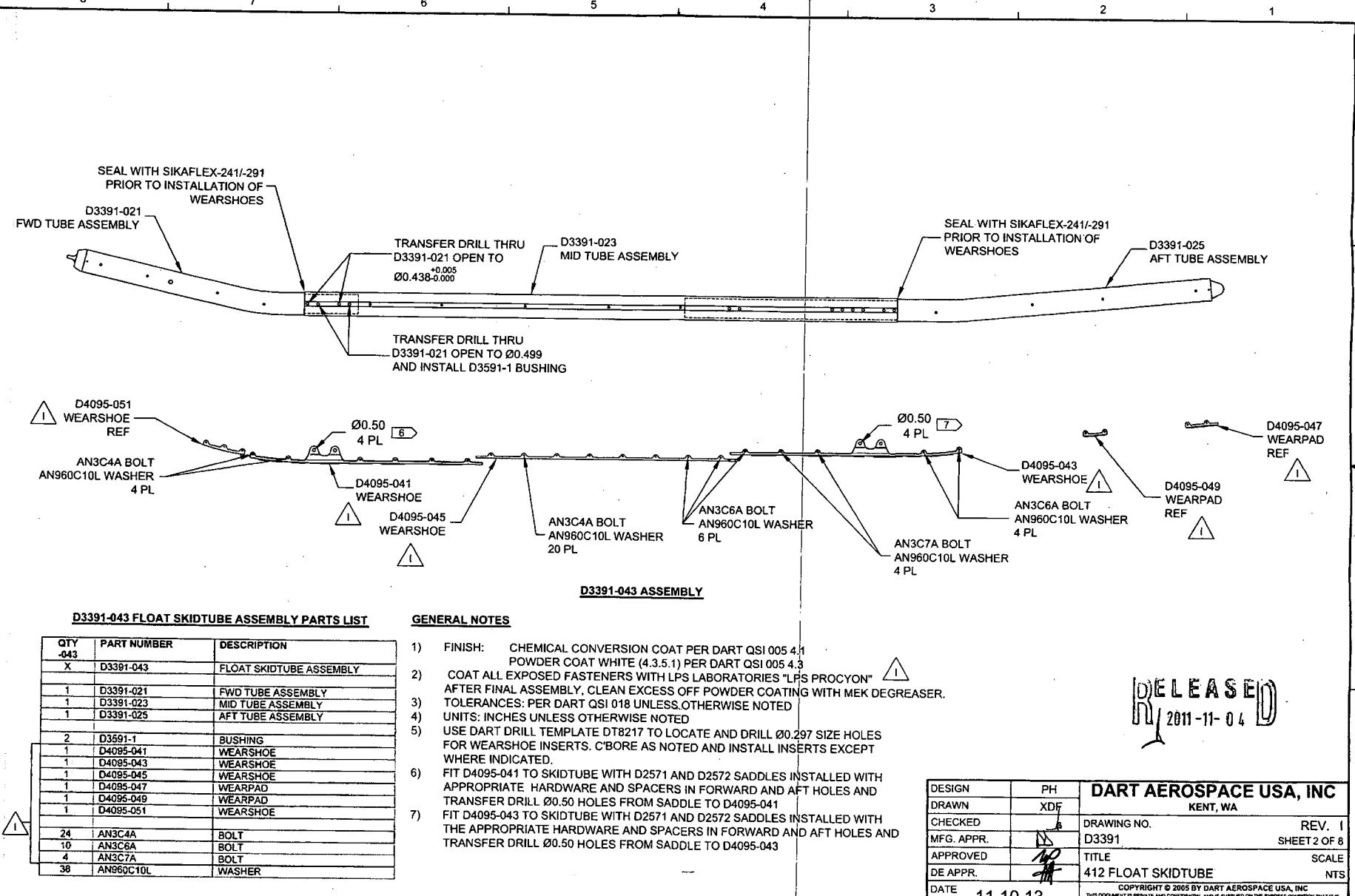
NAS1149C0332R

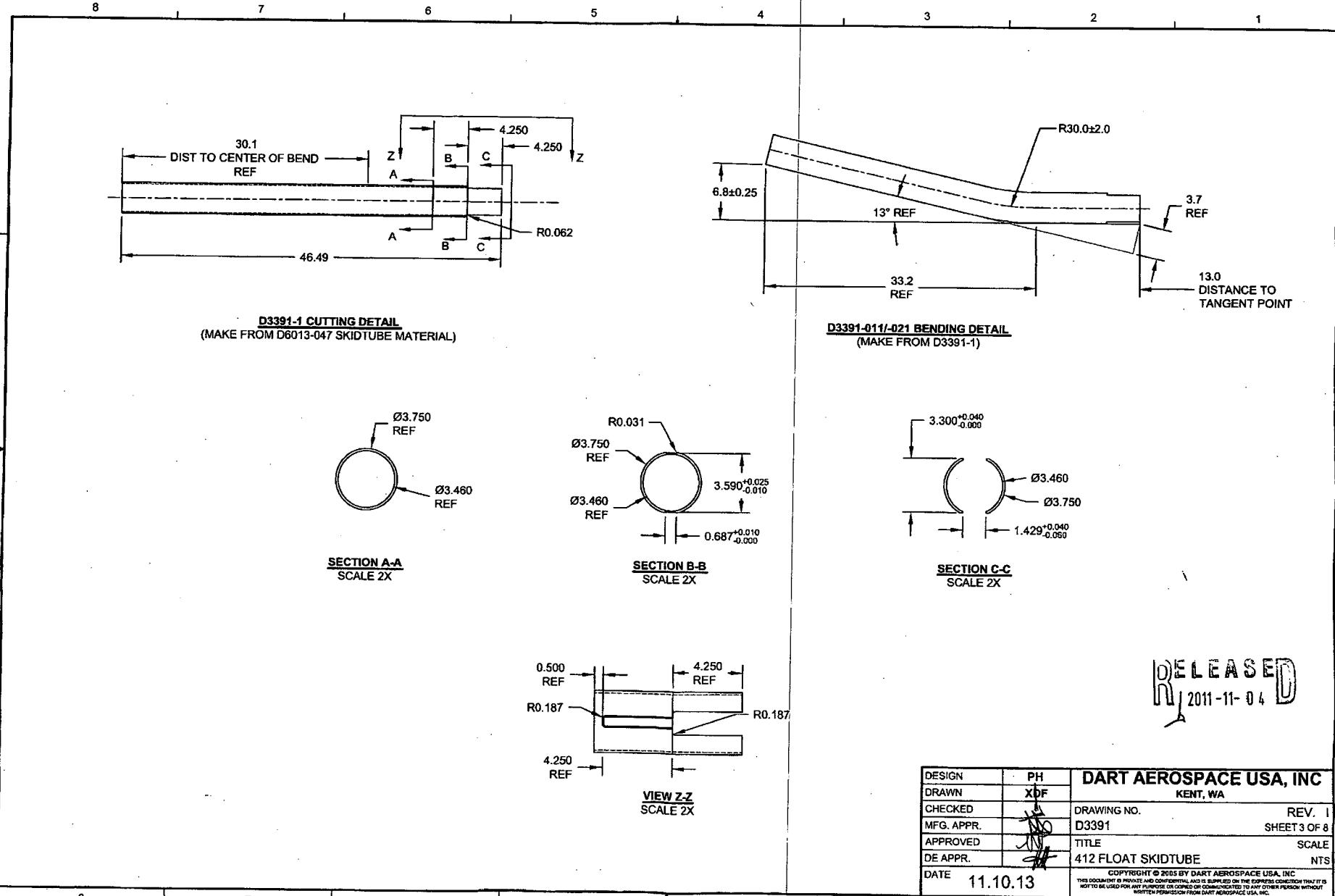
WASHER

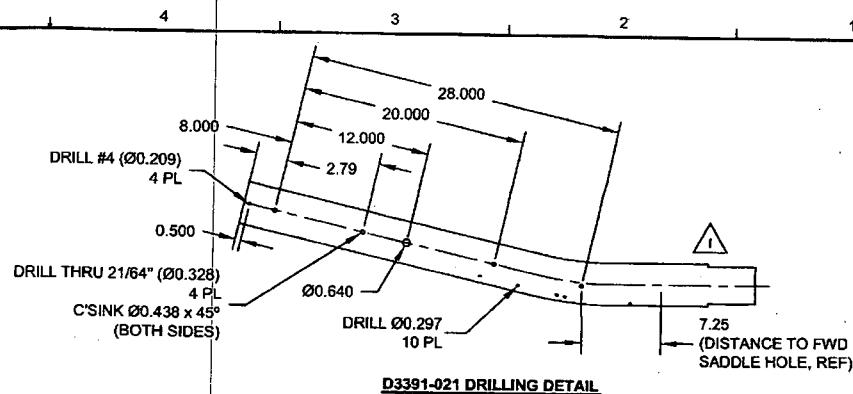
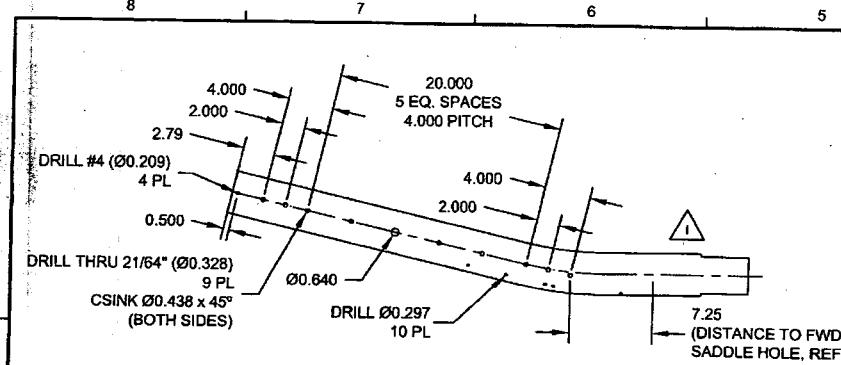
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

GA	1169	
125654	1169	
st510	8483	
m126319	865	
m127306	2500	
m127410	3000	
m127831	2118	



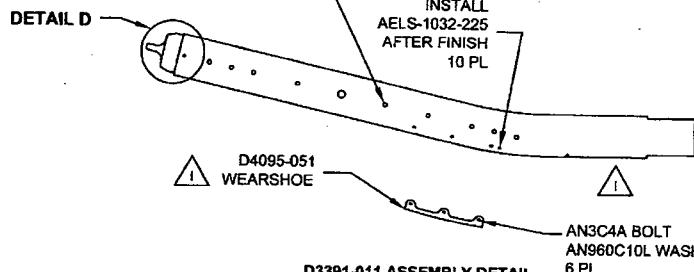




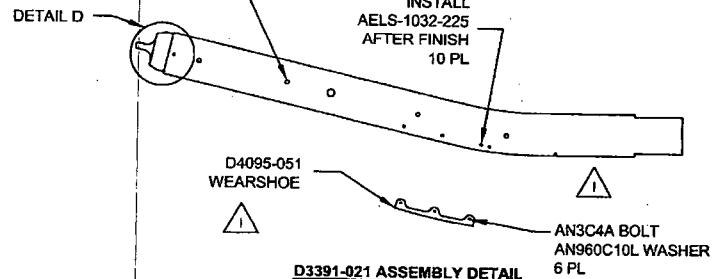


D3391-011 DRILLING DETAIL

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
9 PL



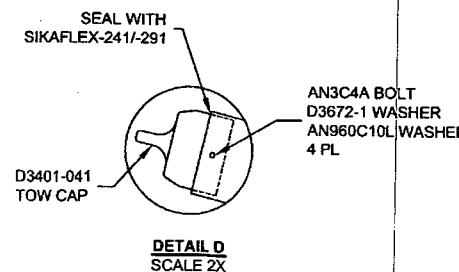
D3391-011 ASSEMBLY DETAIL



D3391-021 ASSEMBLY DETAIL

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY -	QTY -	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
X	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D3401-041	TOW CAP
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
1	1	D4095-051	WEARSHOE
1	1	D6013-047	FWD TUBE
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
10	10	AELS-1032-225	INSERT

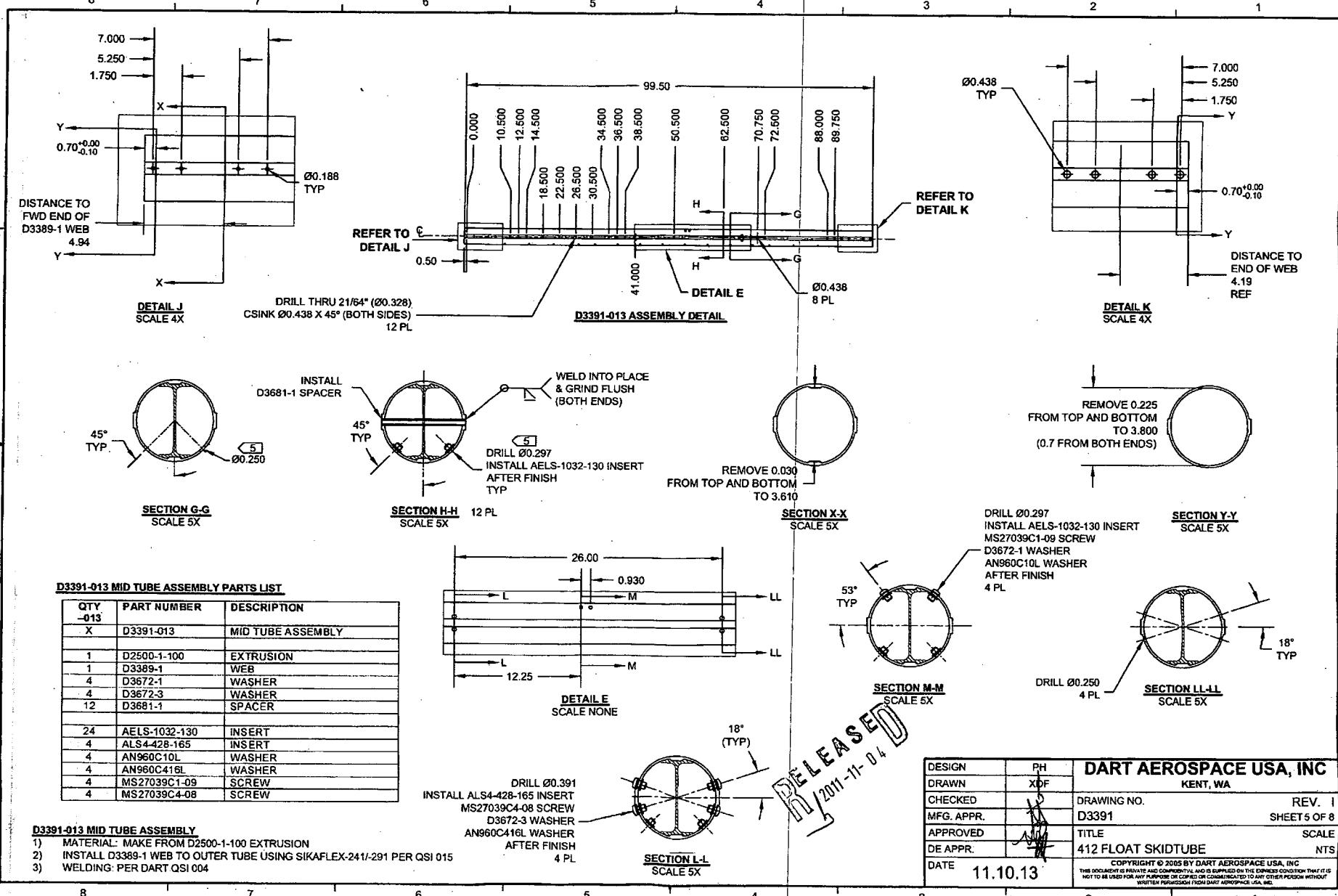


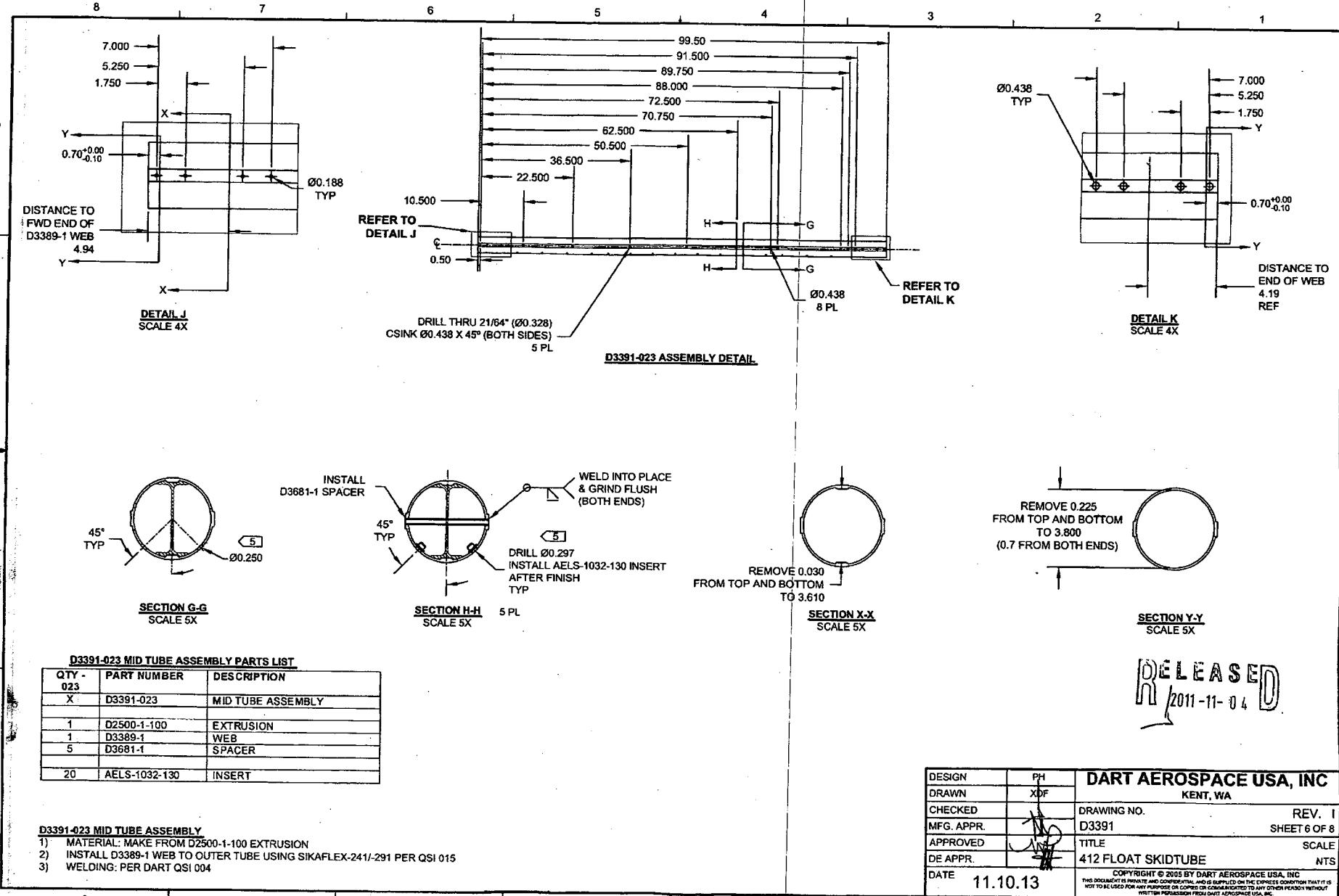
DETAIL D
SCALE 2X

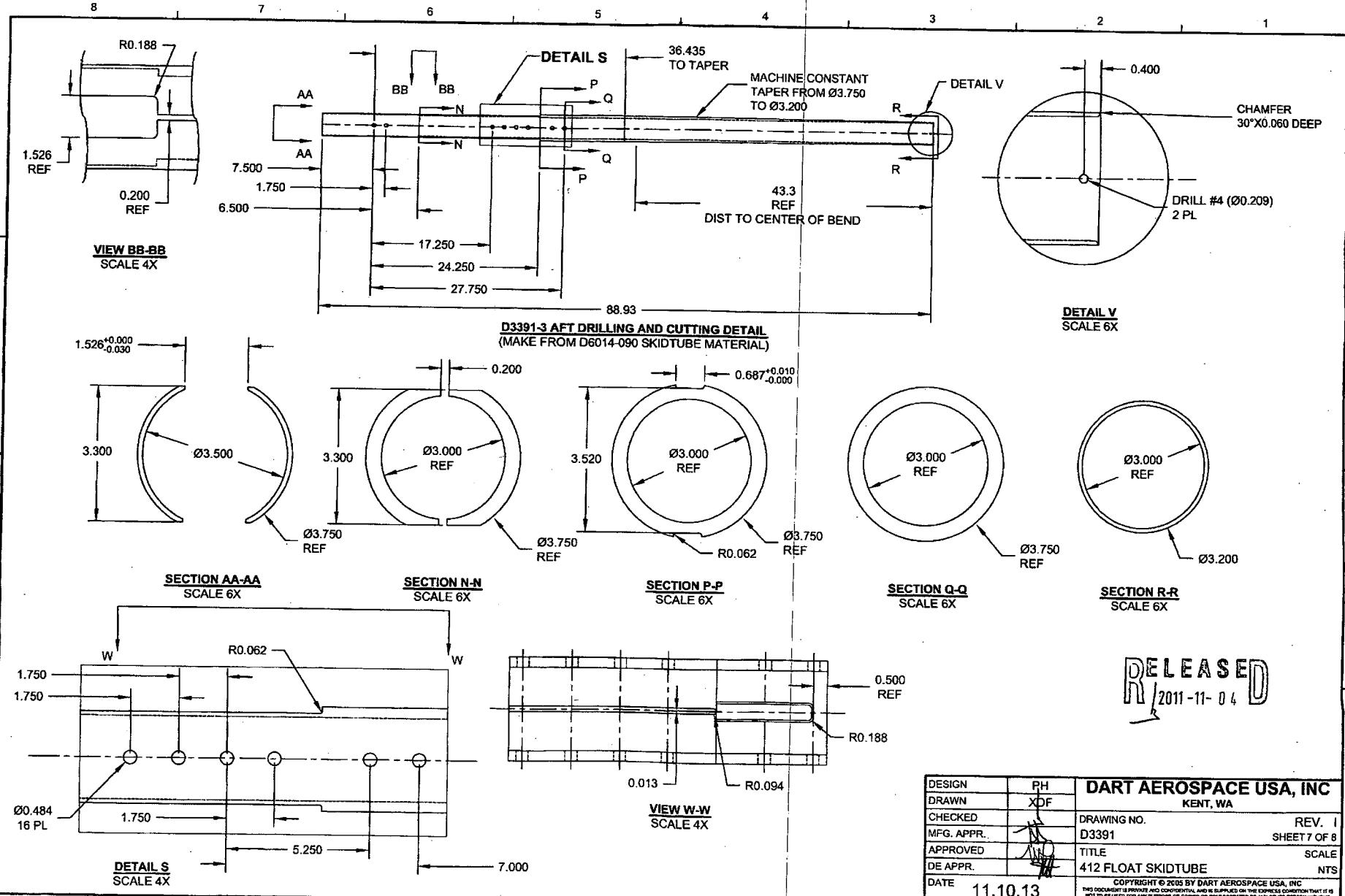
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 4 OF 8
APPROVED		TITLE	412 FLOAT SKIDTUBE
DE APPR.		DATE	11.10.13

RELEASED
2011-11-04

COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS THE PROPERTY OF DART AEROSPACE USA, INC. IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

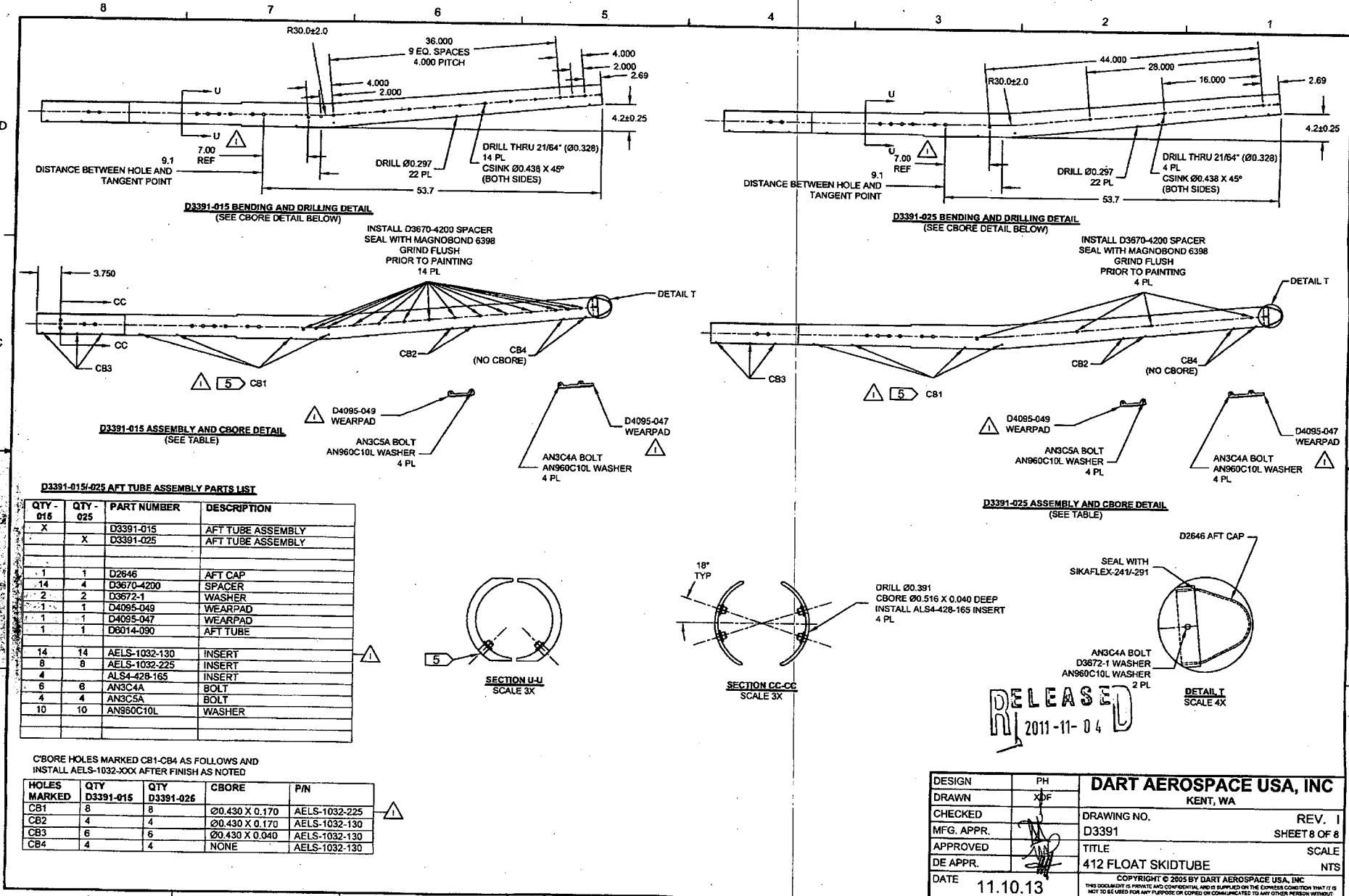






RELEASED
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC		
DRAWN	XDF	KENT, WA		
CHECKED		DRAWING NO.	REV. I	
MGF. APPR.		D3391	SHEET 7 OF 8	
APPROVED		TITLE	SCALE	
DE APPROV.		412 FLOAT SKIDTUBE	NTS	
DATE	11-10-13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE COPIED, REPRODUCED OR DISCLOSED		



RELEASED
2011-11-16

2011-11-0

DESIGN	PH	DART AEROSPACE USA, INC		
DRAWN	XDF	KENT, WA		
CHECKED		DRAWING NO.	REV. I	
MFG. APPR.		D3391	SHEET 8 OF 8	
APPROVED		TITLE	SCALE	
DE APPR.		412 FLOAT SKIDTUBE	NTS	
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC		
THIS DESIGN IS THE PROPERTY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE COPIED OR DISCLOSED				



DART AEROSPACE LTD

Work Order:

112711

Description: Float Skidtube (412)

Part Number:

D3391-3

Inspection Dwg: D3391

Rev: I

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	-		TAPE	LG-25
3.500	+/-0.010	3.500	/		VERN	CNC-000
Ø3.200	+/-0.010	3.204	/			
Ø3.750	+/-0.010	3.750	-			
30° x 0.060 chamfer	+/-0.010	30°x.060	-			
88.93	+/-0.030	88.93	/		TAPE	LG-25

Measured by: CM M.L.

DAS

Date: 14/02/19

Audited by: 27

9-89

Date: 14/02/19

HAAS Section						
1.526	+0.000/-0.030	1.505	-		Vern	ML06
7.500	+/-0.010	7.500	-			
27.750	+/-0.010	27.750	-		TAPE	ML-08
31.750	+/-0.010	31.750	-		"	
35.250	+/-0.010	35.250	/		"	
3.300	+/-0.010	3.300	/		Vern	ML-06
0.200	+/-0.010	.200	/			
3.520	+/-0.010	3.525	/			
0.687	+0.010/-0.000	0.687	/			
R0.062	+/-0.010	R.062	/			
Ø0.484	+0.005/-0.001	0.486	/			

Measured by: CM

Date: 14/03/19

Audited by: J.A.

DAS

Date: 14/03/19

Rev	Date	Change	9-89	Revised by	Approved
A	06.04.24	New Issue	P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update		KJ/JLM	
C	07.04.20	Ø0.208 dimension removed		KJ/JLM	
D	07.09.06	0.400 dimension removed		KJ/JLM	
E	07.11.23	Dwg Rev. updated		KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028		KJ/JLM	
G	09.11.16	Dimension 0.200 removed		KJ	
H	11.06.21	Dimension 44.995 removed		KJ	
I	12.05.15	Dwg Rev updated		KJ	
J	12.05.23	Dimension updated		KJ	
K	12.10.15	88.93 dimension removed		KJ	
L	12.11.28	88.93 dimension added		KJ	

1
2
3
4
5
6
7

8

9
10
11